

Work Order ID 99201

April-01-13 11:48:38 AM

99201

Page 1

Item ID: D2596

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Web. 205 Skidtube

Start Date: 4/01/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/15/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-04-01 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2596	Rev D
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100		0.00
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100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Cut D2500-3-100 to length: 99.5"
2- Use Jig DT8093 to drill pilot holes #30
3- Open to 0.630" diameter as per Dwg D2596
4- Deburr

6 CF 13-4-1

110		0.00
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110

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

6 SAD 13-04-01

120		0.00
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120

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control



13.7.1

6

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>L6</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(6) SMO 13-04-05

13/4/13

13-04-2

Picklist Print

April-01-13 11:48:42 AM

Page 1

Work Order ID: 99201

99201

Parent Item: D2596

D2596

Parent Item Name: Web. 205 Skidtube

Start Date: 4/01/13

Required Date: 4/15/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: D99.02.02Changed QA to QC. Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	203.0000	1	6			

D2500-3-100

Ext'n -1' Beam Web 4"

**

CF 13-4-1

Location

Loc Qty

Loc Code

LG

203

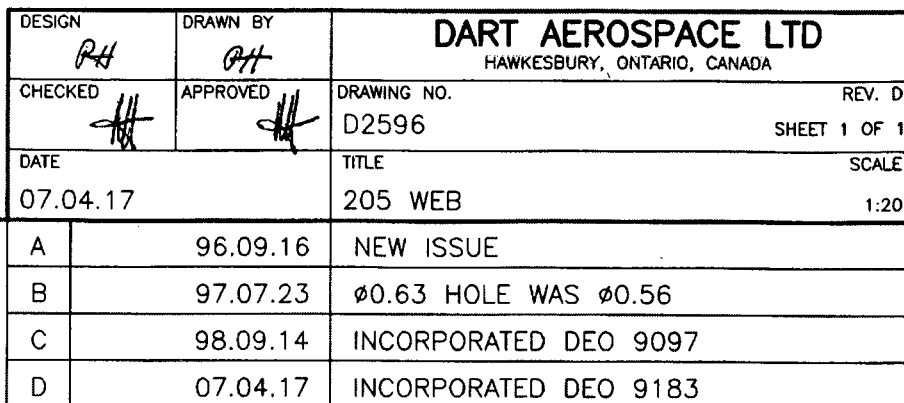
84873

4

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199

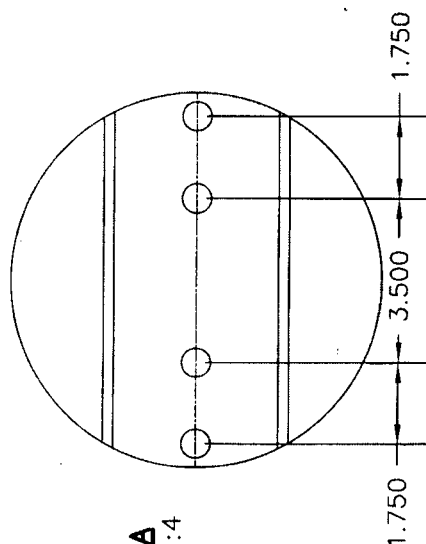
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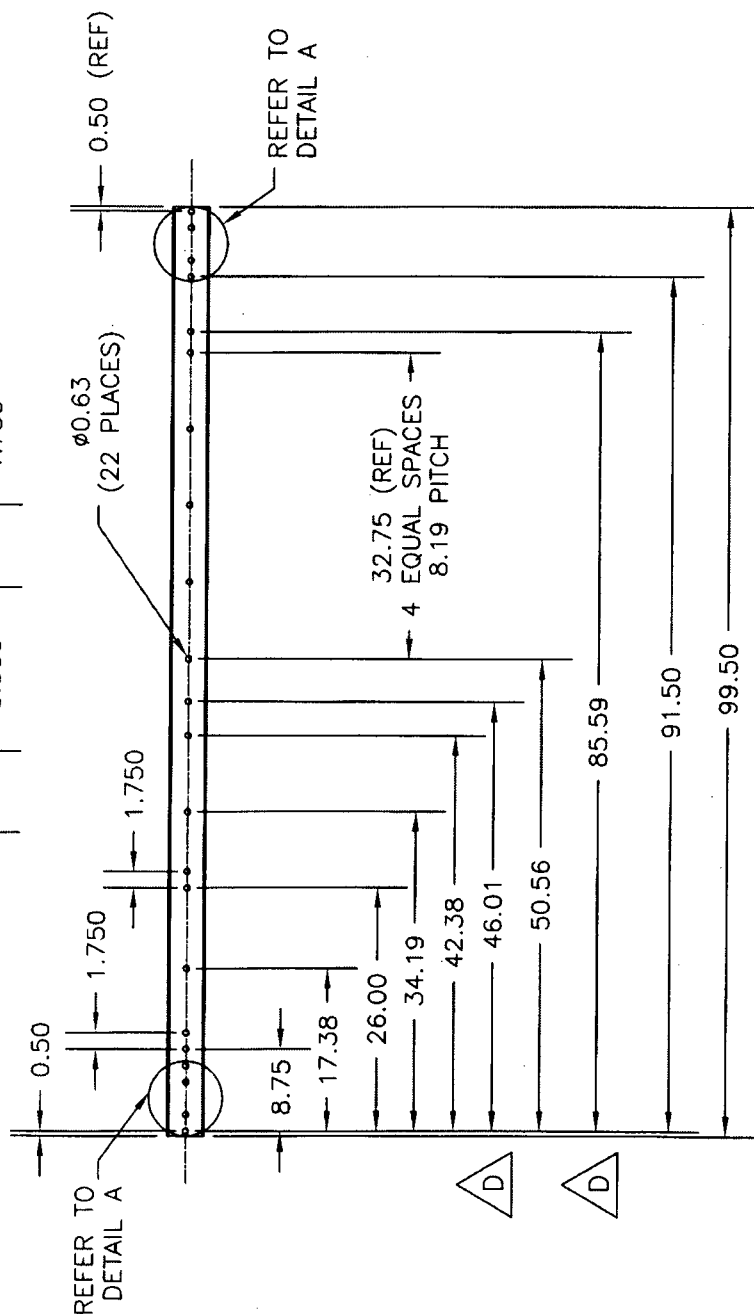
RELEASED
07 DEC 68

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 3000
 2000
 1000
 500
 250
 125
 62.5
 31.25
 15.625
 7.8125
 3.90625
 1.953125
 0.9765625
 0.48828125
 0.244140625
 0.1220703125
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99201 MS
13-04-01



DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) DEBURR SHARP EDGES 0.010 TO 0.020

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